

Date: Friday, 13/02/2009 8:13:24 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLADE FITTING
Job Number : 45782	
Estimate Number : 12300	
P.O. Number :	Part Number : D3488042
This Issue : 13/02/2009 S.O. No. :	Drawing Number : D3488 / DSK101
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : B / D
Previous Run : 44531	Material :
Written By : <i>[Signature]</i> 08-02-13	Due Date : 20/02/2009 Qty: 5 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 06-02-28 JLM Est Rev:B As per Rev B 06-03-30 JLM Est Rev:C Now On Doosan Lathe JLM Verified BY:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6103003	Round Billet, Aluminum
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Alluminum Round Billet D6103-003
 Batch: 45034

SA 02/02/13

2.0	DOOSAN LATHE	DOOSAN LATHE
-----	--------------	--------------



Comment: DOOSAN CNC LATHE
 1-Turn as per Dwg DSK 101 & Folio FA627

2-Deburr

SA 09/02/14

(5)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/02/14

(5)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA627 & Dwg D3488

2-Deburr

SA 09/02/14

(5)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/02/15

(5)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 45782

Part Number: D3488042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

28 09/02/21

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 09/02/23

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 10:00AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 10:30AM

911 09-02-24

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-02-24

10.0

ALS71032225

INSERT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 ALS7-1032-225 Insert

1109817

X

11

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg D3488

11 09-02-27

VS

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/22 09/03/02

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-8

11

09-08-22

Date: Friday, 13/02/2009 8:13:24 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 45782

Part Number: D3488042

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/02 AJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09.03.02

DART AEROSPACE LTD	Work Order:	45782
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2	Part Number:	D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

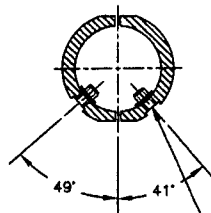
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2.150	✓			
Ø2.780	+/-0.005	2.780	✓			
Ø3.125	+/-0.010	3.125	✓			
Ø3.346	+/-0.010	3.348	✓			
0.125 x 45°	+/-0.010 x +/-0.1°	.125x45°	✓			
8.000	+0.030/-0.000	8.000	✓			
9.250	+/-0.010	9.250	✓			
0.188	+/-0.010	.188	✓			
R0.032	+/-0.010	R.032	✓			
R0.062	+/-0.010	R.062	✓			
Ø0.297	+0.005/-0.001	.301	✓			
Ø0.430	+/-0.010	.430	✓			
0.100	+/-0.010	.100	✓			
0.125	+/-0.010	.125	✓			
2.620	+/-0.010	2.620	✓			
3.500	+/-0.010	3.500	✓			
1.005	+/-0.010	1.005	✓			
Ø0.484	+0.005/-0.001	.485	✓			
1.180	+/-0.010	1.181	✓			
3.150	+/-0.010	3.152	✓			
3.070	+/-0.010	3.071	✓			
R0.063	+/-0.010	R.063	✓			

DART AEROSPACE LTD		Work Order:	45782
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2		Part Number:	D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 2 of 2	

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	Ø.570	—			
0.750	+/-0.010	.750	—			
1.500	+/-0.010	1.500	—			
11.18	+/-0.030	11.182	—			
R0.062	+/-0.010	R.062	—			
0.125	+/-0.010	.125	—			
0.590	+/-0.010	.592	—			
0.793	+/-0.010	.793	—			
1.351	+/-0.010	1.352	—			
1.317	+/-0.010	1.318	—			
1.802	+/-0.010	1.800	—			

Measured by:	<i>gml</i>	Audited by:	<i>BP</i>	Prototype Approval:	N/A
Date:	08/02/15	Date:	09/09/21	Date:	N/A

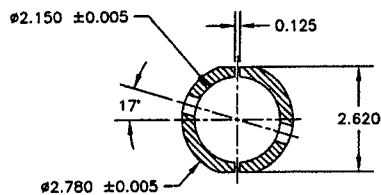
Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-042	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM <i>JA</i>	<i>gml</i>



SECTION B-B

Ø0.297
C'BORE Ø0.430 x 0.100
INSTALL ALS4-1032-225 (OR AKS4-1032-225
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)

w/o 45787
4



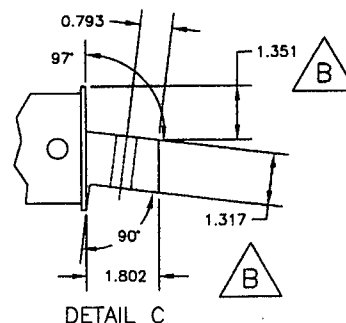
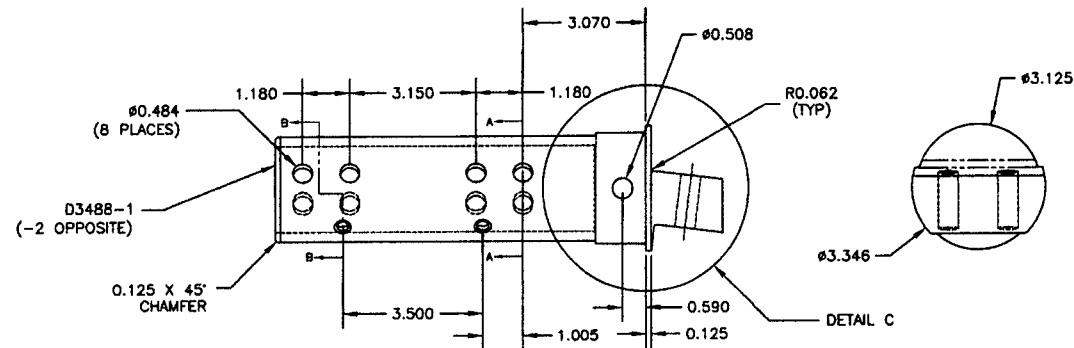
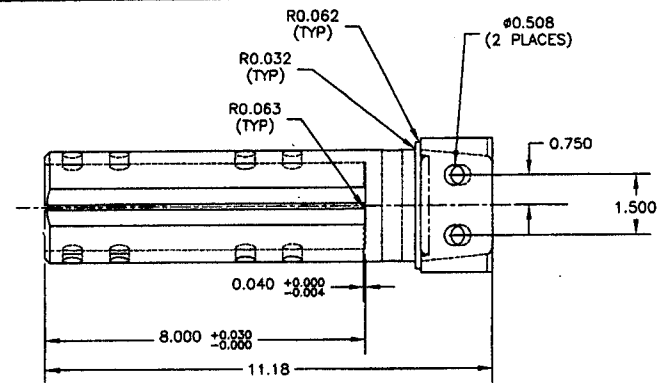
SECTION A-A

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D3488-041	BLADE FITTING ASSEMBLY (LH)
		D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING

- MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR
PER QQ-A-225/9
(REF. DART MATERIAL SPEC M7075T73R)
- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- INSTALL INSERTS AFTER POWDER COAT
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DETAIL C

D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED
06.03.15 PH
PER DS
EIN #787

B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	06.03.15	TITLE
		BLADE FITTING

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DART AEROSPACE USA, INC.
PORT HADLOCK, MA

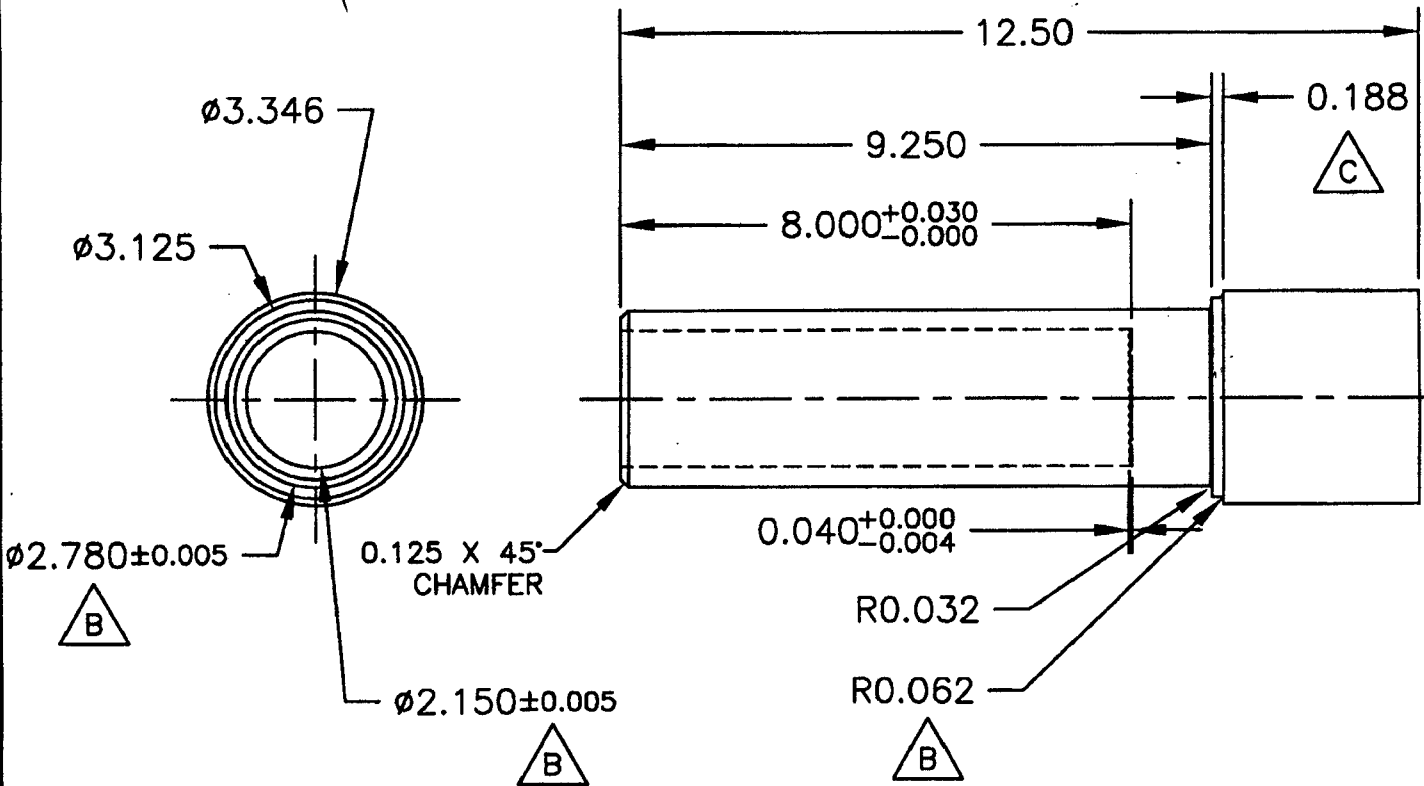
DRAWING NO. D3488
REV. B
SHEET 1 OF 1

SCALE 1:3

8.580

DART

DESIGN	04		DRAWN BY	04	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED		APPROVED		DRAWING NO.		REV. D
				DSK 101	SHEET 1 OF 1	
DATE				TITLE	SCALE	
06.05.09				D3488-1/-2 TURNING DETAIL	1:3	
A	05.12.21			NEW ISSUE		
B	06.03.02			ADD TOLERANCES AND RADIUS		
C	06.04.17			0.188 WAS 0.125		
D	06.05.09			REMOVE DIAMETER FOR CHAMFER		



DSK 101

- 1) MATERIAL: MAKE FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9
(REF. DART MATERIAL SPEC M7075T73R)
- 2) FINISH: NONE
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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